

Work Order ID 161063

Monday, May 08, 2017 9:09:02 AM

161063

Page 1

Item ID: PB67-43001-319

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Gusset

Start Date: 5/23/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/25/2017 Req'd Qty: 10.00

10

Customer:

Reference: SCHEDULED/U

Approvals: Process Plan: DAS Date: MAY 08 2017

Tooling:

Date:

Run Start

NR1QC: 21
9-89

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

B67-43001

C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.24

FLOW CNC Waterjet

1-Cut as per Dwg B67-43001

Dwg Rev: CProg Rev: C

2-Deburr if necessary

1005/17/13

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.10

Quality Control

1005/17/13

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.20

Quality Control

10DAS
38
9-89
MAY 15 2017

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>W1003</i>	0.00							
130									
Packaging	Memo	0.10							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	1.00							
Quality Control									

12 MAY 16 2017*DAS*
9-89*17/5/16* *AS**DAS*
21
9-89

MAY 16 2017

Picklist Print

Monday, May 08, 2017 9:09:01 AM

Page 1

Work Order ID: 161063

161063

Parent Item: PB67-43001-319

PB67-43001-319

Parent Item Name: Gusset

Start Date: 5/23/2017

Required Date: 5/25/2017

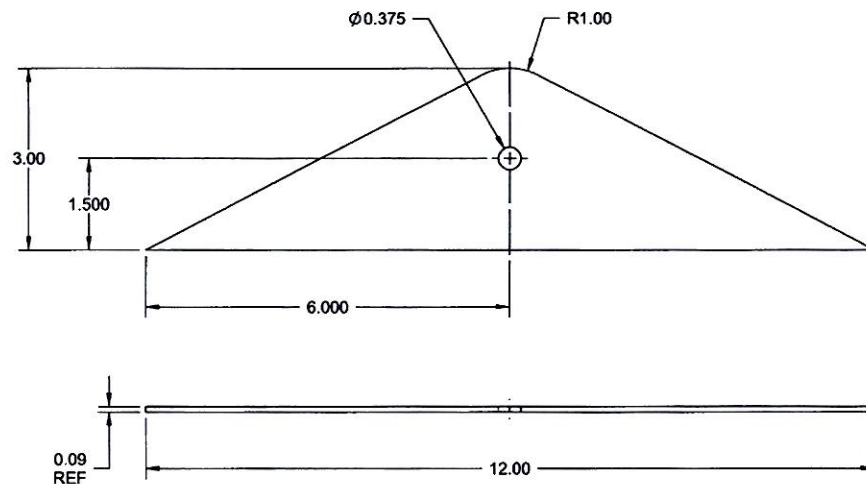
Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-06-23 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.090		Purchased	No			100	sf	3.5700	0.25	2.631579			
M6061T6S 090									**				
6061-T6 .090 Sheet													
				<u>Location</u>				<u>Loc Qty</u>					
				MAT020				3.57					
				M134147				3.57					
										<u>2.7</u>			

05/17/13



B67-43001-319 GUSSET

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.090 THICK
PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF. DART SPEC. M6061T6S.090
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.16 lbs

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 161063 HJS
170508

RELEASED
2009-09-26
MD

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PART 09-011.		MB	09.03.11
REV.		DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN					
CHECKED	ASS	DRAWING NO. B67-43001-319		REV. C	
MFG. APPR.		TITLE GUSSET		SCALE	
APPROVED				NTS	
DE APPR.	N/A				
DATE	09.03.11	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			